

Date: Monday, 07/04/2008 11:46:54 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP (CASTING DETAIL)		
Job Number	: 38420			Part Number	: D25761		
Estimate Number	: 11088			Drawing Number	: D2576 REV G		
P.O. Number	:			Project Number	: N/A		
This Issue	: 07/04/2008	S.O. No.	:	Drawing Revision	: G		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: PURCHASED PARTS	Due Date	: 14/04/2008	Qty:	100
Previous Run	: 33320			Um:	Each		
Written By	:						
Checked & Approved By	: <u>SL</u> 08.04.06						
Comment	: Est Rev: A New Issue 05-11-29 JLM est rev B rev F dwg 07.07.06 EC Est Rev:C As per Rev G 07-09-05 JLM Verified By:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING 
<b>Comment:</b> PURCHASING Issue P/O: <u>6082</u> Ship D2576 mould to vendor Cast per D2576-1 Pattern Material Release Note Required		
2.0	D25761P	Step (Casting Detail) 
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) STEP		
3.0	PACKAGING 1	PACKAGING RESOURCE #1 
<b>Comment:</b> PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure D2576 mould is returned with the ordered parts Ensure release note is attached		
4.0	QC6	DIMENSIONAL CHECK 
<b>Comment:</b> DIMENSIONAL CHECK		
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location:		

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services Drawing Name: STEP (CASTING DETAIL)

Job Number: 38420 Part Number: D25761

Job Number: 

Seq. #: Machine Or Operation: Description :  
6.0 QC21 FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion  MF 08-05-27

4.75

3

K 1.28 SLOT

1.66  
(TYP)  
G G

RELEASED  
07.08.29

G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18

REV.	DESCRIPTION	BY	DATE
DESIGN	<i>4</i>	DART AEROSPACE LTD	
DRAWN	<i>5</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>91</i>	D2576	SHEET 1 OF 1
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	STEP	1:3
DATE	07.08.15	COPRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**ALPINE NON-FERROUS FOUNDRY**  
 8657-132ND STREET  
 SURREY, B.C. V3W 4P1

**WORK ORDER**

Tel:(604) 596-8080      Fax: (604) 596-8045

**Sold To:** **DART AEROSPACE**  
 1270 ABERDEEN STREET  
 HAWKESBURY, ONT K6A 1K7  
 CANADA

**Ship To:** **DART AEROSPACE**

Order Date		Purchase Order#	Due Date	Ship Via			P
07-Apr-2008		PO00006082	25-Apr-2008	FEDEX			
Item#	Item Code	Description		Material	Ordered	B/O	Qt
1	DART D2576	D2576 STEP CSTG			100		
2							

**Comments**

Castings&Patterns are property of Alpine until paid in full

Apr. 23/08

# CERTIFICATE OF ANALYSIS

CUSTOM ALLOY LIGHT METALS  
13329 ECTOR STREET CITY OF INDUSTRY, CA 91746  
PH# (626) 369-3641 FAX# (626) 369-2471

**CUSTOMER:**

RYPAC ALUMINUM  
11849 TANNERY ROAD  
SURREY BRITISH COLUMBIA,

SHIP DATE

*MAR 03 2008*

CONFORMS TO ASTM SPECIFICATION: B179-06

Alloy: 535.2

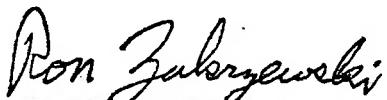
Heat: A7880

Si	0.060	Si	.10
Fe	0.057	Fe	.10
Cu	0.007	Cu	.05
Mn	0.128	Mn	.10-.25
Mg	6.990	Mg	6.6-7.5
Cr	0.001	Cr	
Zn	0.011	Zn	.05
Ti	0.135	Ti	.10-.25
Sn	0.003	Sn	
Pb	0.001	Pb	
Ni	0.000	Ni	
OET	< .15	OET	.15
Sr	0.000	Sr	
Al	REMAINDER	Al	REMAINDER

BE .004

BE .003-.007

ELEMENTS LISTED WITHOUT A RANGE, UNDER THE REQUIRED SPECIFICATIONS, ARE MAXIMUM ALLOWABLE PERCENTAGES. SAMPLES ANALYZED ON AN OPTICAL EMISSION SPECTROMETER WITH CURRENT CALIBRATION STATUS. STANDARDS ARE NIST OR ARE TRACEABLE TO NIST.



RON ZAKRZEWSKI

LAB MANAGER  
FM-1201 Rev D 12/5/2001

*MAR 03 2008*

DATE

WARNING: THE BUYER IS ADVISED THAT THIS METAL MAY CONTAIN CAVITIES AND HIDDEN RECESSES HOLDING ENTRAPPED MOISTURE. THE METAL SHOULD BE HANDLED AND PROCESSED WITH THIS POSSIBILITY IN MIND. ENTRAPPED MOISTURE MAY CAUSE AN EXPLOSION IF THE METAL IS INTRODUCED INTO A MELTING FURNACE WITHOUT PROPER DRYING.